

**Work Order ID 54213**

December 03, 2009 9:21:59 AM



Page 1

Item ID: D205-596-105

Accept



Setup Start



Revision ID: B

Stop



Item Name: Crosstube Fwd Extended

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 09/12/3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D205-596	Rev B

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy D205-594 bluefile &amp; type labels per PPP D205-596-105 CHG002

*for MF 10/01/02*

110



BENDING MACHINE - CROSSTUBES

0.00

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend as per Dwg D2889 using CNC bender program

*MB 09-12-15*

120



Crosstubes

0.00

Crosstubes

Memo

0.00

Crosstubes

Mark 23.92" for cutting from tangential line in the straight section from D2889  
as per Dwg wall template.

*[initials]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

**Item ID:** D205-596-105

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Setup Start

**Revision ID:** B

Stop

**Item Name:** Crosstube Fwd Extended**Start Date:** 12/3/2009 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 12/22/2009 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

• Mark cut lines at bottom of loose tube  $\Rightarrow S_{09}11215$   
 Memo 0.00

(X)

140



Crosstubes

Crosstubes

0.00

Memo

0.00

1-Cut as per Dwg D205-596-105

2-Deburr &amp; Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

AWB 8-10-01-04

150



Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

 $\Rightarrow S_{10}105$ 

(R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 54213**

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Revision ID: B

Stop



Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Crosstubes Chemical Conversion

0.00

A.W.M  
10-01-07

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

170



SprayPaint

0.00

M 10/01/07 (J)

SprayPaint

Memo

0.00

Spray Painting 1-Prime inside and outside with Immron per QSI 005 4.2

180



QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

RT 10-01-11 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 54213

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Item ID: D205-596-105

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Revision ID: B

Item Name: Crosstube Fwd Extended

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

190



Crosstubes

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

Crosstubes

Memo

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area  
with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-105 Magnobond 6398

Batch: 112417 EXP: 01/2011

3- Inst

Torque: M10 10/01/12

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ S (0) 01/12

0.00

Memo

40

210



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D205-596-105

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

10/01/13 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

220



QC

Quality Control

**Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/15 AF

MF 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Picklist Print**

December 03, 2009 9:21:59 AM

Page 1  
*3***Work Order ID:** 54213**Parent Item:** D205-596-105RevB**Parent Item Name:** Crosstube Fwd Extended**Start Date:** 12/3/2009**Required Date:** 12/22/2009**Comments:****Start Qty:** 1.00**Required Qty:** 1.00

<b>Component Item ID/ Item Name</b>	<b>Replacement Item ID</b>	<b>Mfg/ Purch</b>	<b>Bin Item</b>	<b>Primary Location</b>	<b>Last Location</b>	<b>Route Seq ID</b>	<b>Unit of Measure</b>	<b>Qty on Hand</b>	<b>Remaining Qty To Pick</b>	<b>Qty Issued</b>	<b>Date Issued</b>	<b>Status</b>
---	--------------------------------	-----------------------	---------------------	-----------------------------	--------------------------	-------------------------	----------------------------	------------------------	----------------------------------	-----------------------	------------------------	---------------

D6005-180RevA



Manufactured

No

110

Each

11.0000

1.0000

*DMB 09-12-15 ✓*

Crosstube Material

<b>Warehouse</b>	<b>Loc Qty</b>	<b>Loc Code</b>
------------------	----------------	-----------------

Location

Main Warehouse

LG

11

39734

11



D2893-1RevB



Manufactured

No

190

Each

72.0000

2.0000



2.75 Support

<b>Warehouse</b>	<b>Loc Qty</b>	<b>Loc Code</b>
------------------	----------------	-----------------

Location

Main Warehouse

ST

72

25657

6

47109

2

47637

16

51775

19

53125

19

53340

10

*m 10/01/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

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December 03, 2009 9:21:59 AM

Work Order ID: 54213



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased		No		190	Each	201.0000	4.0000			



Clamp(per MIL-DTL-8783C)

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST	201	
107456	2	
108111	3	
108975	17	
109181	42	
109644	10	
111282	4	
111429	1	
<u>112495 x 1</u>	22	
<u>112919 x 3</u>	25	
113281	25	
113282	50	

10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Picklist Print**

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December 03, 2009 9:21:59 AM

Work Order ID: 54213



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3595-063-450RevA		Manufactured		No		190	Each	196.9689	4.0000			

RUBBER CUSHION

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>
-----------------

Main Warehouse

LG	92	
----	----	--

52447	92	
-------	----	--

Main Warehouse

ST	104.9689	
----	----------	--

38959	2	
-------	---	--

43210	2.59	
-------	------	--

46465	0.3789	
-------	--------	--

53775	100	
-------	-----	--

m/ 18/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6005-180  
FINISHED LENGTH =  $134.40 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

RETUR  
 ENGINE  
 UNCONTROLLED  
 SUBJECT TO AMENDMENT  
 WITHOUT NO  
 WORK ORD  
 NO. 54063  
 PL09123

DETACHED

RELEASED  
06.01.16 M

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24			MB	07.12.03
A	NEW ISSUE			DS	02.11.20
REV.	DESCRIPTION			BY	DATE
DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	1				
CHECKED	PH	DRAWING NO.		REV. B	
MFG. APPR.	E	D205-596-105		SHEET 1 OF 2	
APPROVED	H	TITLE		SCALE	
DE APPR.	H	CROSSTUBE ASSEMBLY, HI-HI FWD		NTS	
DATE	07.12.03		COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

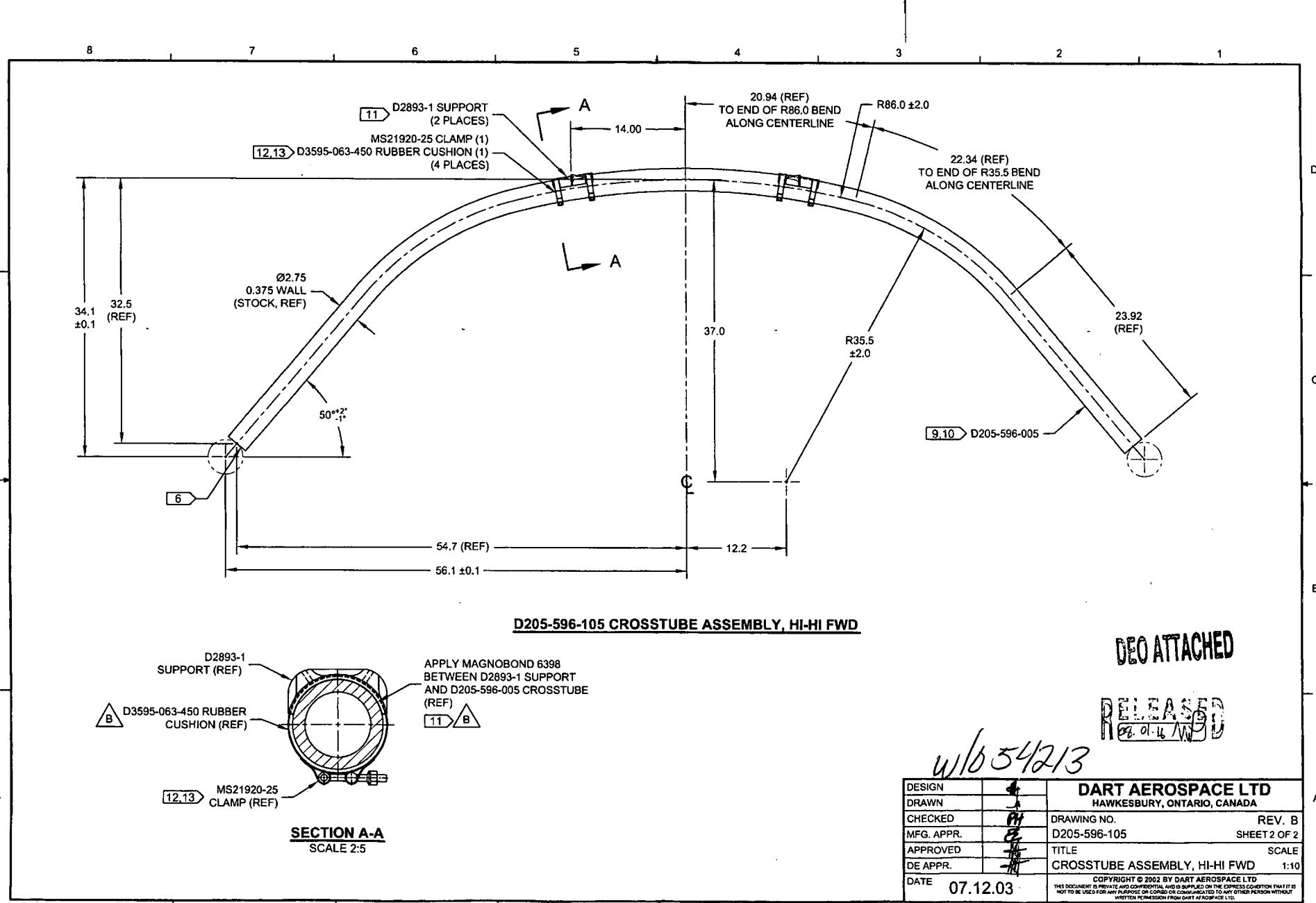
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWING NO. D205-596-105	TITLE CROSSTUBE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D205-596-105-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>PB</i>	MFG. APPR. <i>M</i>	APPROVED <i>MD</i>	DE APPR. <i>W</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09/06/22	DATE 09/06/22	DATE 09.06.22	DATE 09.06.22	w/o 54213

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D205-596-105B	CROSSTUBE ASSEMBLY (214 HI-HI FWD)

THE D205-596-105B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-105 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-105 CROSSTUBE.

**RELEASED**  
*09/06/22 AD*

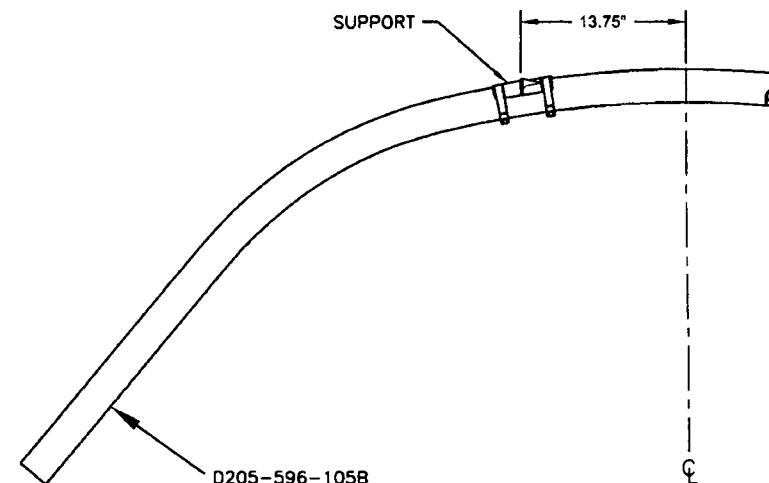


FIGURE 1 - SUPPORT INSTALLATION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

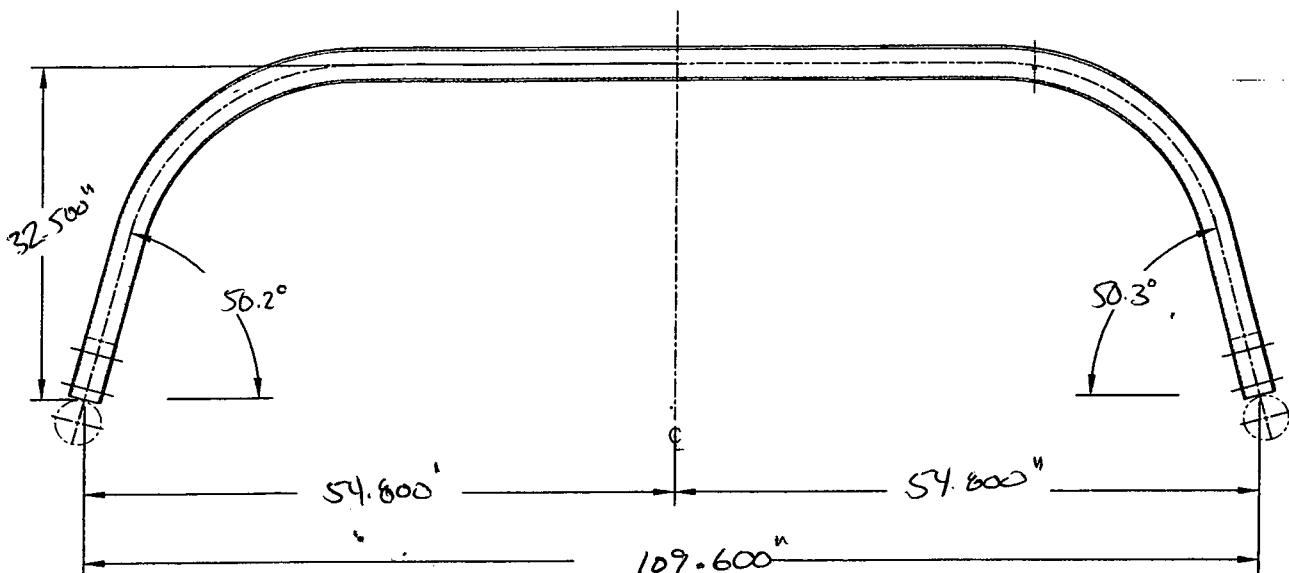
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54213
Description: Crosstube High-High Fwd	Part Number:	D205-596-105
Inspection Dwg: D205-596-105	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments
Tube is @ max. width on
wdt

QC15 Inspection	S
Date	08/02/15

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	JM

W/O:		WORK ORDER CHANGES					
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